



Dart Aerospace Ltd.
1270 Aberdeen St
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D119-675-111
Job Sheet 190051



Part No: D119-675-111

Job Qty: 2 pcs

Part Name: Heli-Access-Step™ LH - DART Crosstube Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/4/19

Job Tracking No:

Due Date: 3/29/19

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV C IPP REV:A 15.11.09 PER IIN REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	2 pcs		3/29/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____	
Description Work Order Deviation		Completed By Lead hand / Supervisor QC / QA Coordinator Container No: S150805 Job No: 190051 Part: D119-675-111 Serial No/Batch: S150805 Revision: Inspector: Exp Date: Instructions: FAA STC SR00948SE 15/04/2015 L0A C-11 DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details: _____			

120	QC 4	2 pcs	3/29/19	0.00 0.00	Packaging 1 - 32						
					Packaging 1 - 33						
					Packaging 1 - 34						
					Packaging 1 - 35						
					Packaging 1 - 36						
					QC 4 - 26						
					QC 4 - 28						
					QC 4 - 38						
					QC 4 - 42						
					QC 4 - 58						
					QC 4 - 6						
					QC 4 - 69						
					QC 4 - 9						
					QC 4 - 46						
					Packaging 3 - 1 - B4B						
					Packaging 3 - 2 - B4B						
					Packaging 3 - 3 - B4B						
					Packaging 3 - 4 - B4B						
					Packaging 3 - 5 - B4B						
					Packaging 3 - 6 - B4B						
130	Packaging 3-1 - Stock - B4B	2 pcs	3/29/19	0.00 0.00	Packaging 3 - 7 - B4B						
					Packaging 3 - 8 - B4B						
					Packaging 3 - 9 - B4B						
					Packaging 3 - 10 - B4B						
					Packaging 3 - 11 - B4B						
					Packaging 3 - 12 - B4B						
					Packaging 3 - 13 - B4B						
					Packaging 3 - 14 - B4B						
					Packaging 3 - 15 - B4B						
					Packaging 3 - 16 - B4B						
					Packaging 3 - 17 - B4B						
					Packaging 3 - 18 - B4B						
					Packaging 3 - 19 - B4B						
					Packaging 3 - 20 - B4B						
					Packaging 3 - 21 - B4B						
					Packaging 3 - 22 - B4B						
					Packaging 3 - 23 - B4B						
					Packaging 3 - 24 - B4B						
					Packaging 3 - 25 - B4B						
					Packaging 3 - 26 - B4B						
					Packaging 3 - 27 - B4B						
					Packaging 3 - 28 - B4B						
					Packaging 3 - 29 - B4B						
					Packaging 3 - 30 - B4B						
					Packaging 3 - 31 - B4B						
					Packaging 3 - 32 - B4B						
					Packaging 3 - 33 - B4B						
					Packaging 3 - 34 - B4B						
					Packaging 3 - 35 - B4B						
					Packaging 3 - 36 - B4B						
					135	DC - 1 - B4B	2 pcs	3/29/19	0.00 0.00	DC - 1 - B4B	
										DC - 2 - B4B	
					140	QC 21 - FG	2 pcs	3/29/19	0.00 0.00	QC 21 - FG - 21	
										QC 21 - FG - 70	
										QC 21 - SA - 53	
					Part Op 110 - (Pick Kit)						
Descriptions: 120 - (QC4- 100% Inspect kits for completeness)											
130 - Identify and pack for shipping as per PPP D119-675-111 Location : FG107											
135 - (Document Control) Photocopy bluefile & type labels per PPP D119-675-111 CHG001											
140 - (QC21- Final Inspection - Work Order Release)											

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Date : _____		Sequence # : _____		QTY Affected : _____		MRB (QSI042) ☐	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
Other/Details: _____							

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-15A	Bolt	8 Ea (4 ea)	110-Packaging 1 - Pick Kit	5133173x4 5134 1/36x4
AN4-16A	Bolt	8 Ea (4 ea)	110-Packaging 1 - Pick Kit	5119148
AN4-22A	Bolt	8 Ea (4 ea)	110-Packaging 1 - Pick Kit	5097470
D2617-3	Bushing	8 pcs (4 ea)	110-Packaging 1 - Pick Kit	5148238
D2617-5	Spacer	8 pcs (4 ea)	110-Packaging 1 - Pick Kit	5137866
D2732-032	Rubber Cushion - 3.2"	16 pcs (8 ea)	110-Packaging 1 - Pick Kit	5141599
D3043-041	Step Weldment LH	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5142595
D5283-041	Basket Clamp Assembly	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	5110284
D5283-043	Basket Clamp Assembly	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	5109625
D5283-11	Basket Clamp	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	5116156x2 5116146x2
D5283-7	Basket Clamp	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	5116111
MS21042L4	Nut	24 Ea (12 ea)	110-Packaging 1 - Pick Kit	5149814
NAS1149D0463J	Washer	48 Ea (24 ea)	110-Packaging 1 - Pick Kit	5130345

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN4-15A	8	424	0
	AN4-16A	8	633	0
	AN4-22A	8	137	0
	D2617-3	8	37	0
	D2617-5	8	63	0
	D2732-032	16	56	0
	D3043-041	2	2	0
	D5283-041	4	11	0
	D5283-043	4	13	0
	D5283-11	4	43	0
	D5283-7	4	38	0
	MS21042L4	24	3,551	0
	NAS1149D0463J	48	5,031	0

Part Specifications

Specifications could not be found.

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Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

5.0 PARTS LISTS

5.1 Heli-Access-Step™ Parts List

ITEM	Qty -011	Qty -012	Qty -111	Qty -112	Part Number	Description
	X				D119-675-011	HELI-ACCESS-STEP™, LH
		X			D119-675-012	HELI-ACCESS-STEP™, RH
			X		D119-675-111	HELI-ACCESS-STEP™, LH
				X	D119-675-112	HELI-ACCESS-STEP™, RH
1	4	4	4	4	D2617-5	BUSHING
2	4	4	4	4	D2617-3	BUSHING
3	8	8	8	8	D2732-032	RUBBER CUSHION
4	1		1		D3043-041	STEP WELDMENT LH
5		1		1	D3043-042	STEP WELDMENT RH
6	4	4			D3041-1	CLAMP
7	2	2			D3041-3	CLAMP
8	4	4			D3041-5	CLAMP
9	2	2			D3041-7	CLAMP
10			2	2	D5283-7	CLAMP
11			2	2	D5283-11	CLAMP
12			2	2	D5283-041	CLAMP
13			2	2	D5283-043	CLAMP
14	4	4	4	4	AN4-15A	BOLT
15	8	8	4	4	AN4-16A	BOLT
16			4	4	AN4-22A	BOLT
17	24	24	24	24	NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

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Revision: C

Date: 15.07.20